

Date: Wednesday, 13/08/2008 10:55:03 AM
User: Julie Lecocq

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: TUBE DETENT CLIP BASE
Job Number	: 41205		
Estimate Number	: 11294		
P.O. Number	:	Part Number	: D34409
This Issue	: 13/08/2008 S.O. No. :	Drawing Number	: D3440 REV A
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: / / Type : MACHINED PARTS	Drawing Revision	: A
Previous Run	:	Material	:
Written By	:	Due Date	: 15/09/2008 Qty: 8 Um: Each
Checked & Approved By	: <u>JUL 08.8.13</u>		
Comment	: Est. A 05.06.30 New issue KJ/JLM		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

1.0	M6061T6B1250X01250	6061-T6 Bar 1.25 x 1.25
-----	--------------------	-------------------------



Comment: Qty.: 0.1706 f(s)/Unit Total: 0.6825 f(s)
6061-T6 Bar 1.25 x 1.25"
Material: 6061-T6 Bar 1.250" x 1.250"
(M6061T6B1.250x01.250)
Identify for D3440-9
Batch: M106259

JL 08/08/14

2.0	BAND SAW	BAND SAW
-----	----------	----------



Comment: BAND SAW
Cut blank: 1.250" x 1.250" x 1.825" long

JL 08/08/14

3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
-----	-------	--------------------------------



Comment: HAAS CNC VERTICAL MACHINING #1
Machine as per Folio FA535 and Dwg D3440
Dwg Rev: A
Identify as D3440-9
Folio Rev: AA
Deburr

DTP 08/08/21

PTO → (8)

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
-----	-----	--



Comment: INSPECT PARTS AS THEY COME OFF MACHINE



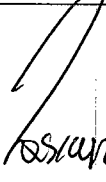
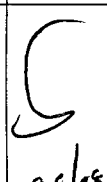
DTP 08/08/21

(8)

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3440-9 PAR #: N/A Fault Category: Machined Parts NCR: Yes No DQA: D Date: 08/08/25
B67-43001-07 QA: N/C Closed: D Date: 08/08/26

NCR: <u>41205</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
08/08/22	3.0	1 part - Tap broke into part. RC Tap broke, Tap was clogged up with material.		Scrap and Replace Batch # <u>106259</u>	08/08/22 DJT			

NOTE: Date & initial all entries

Date: Wednesday, 13/08/2008 10:55:03 AM
User: Julie Lecocq

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: TUBE DETENT CLIP BASE

Job Number: 41205

Part Number: D34409

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC8

SECOND CHECK



Comment: SECOND CHECK

mk 08/08/22

(8)

6.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: *93*

8/8/25

(8x)

SL

7.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/08/25

Job Completion



U 08-08-25

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

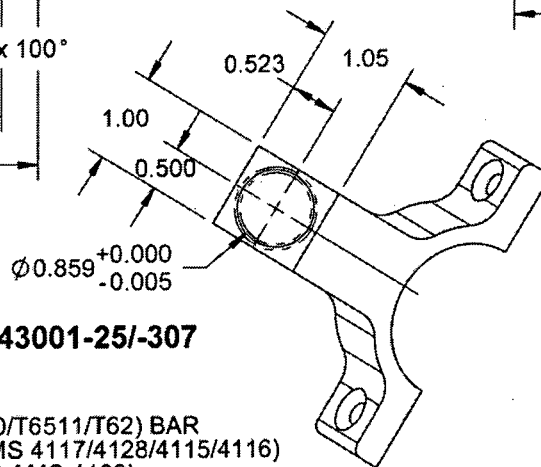
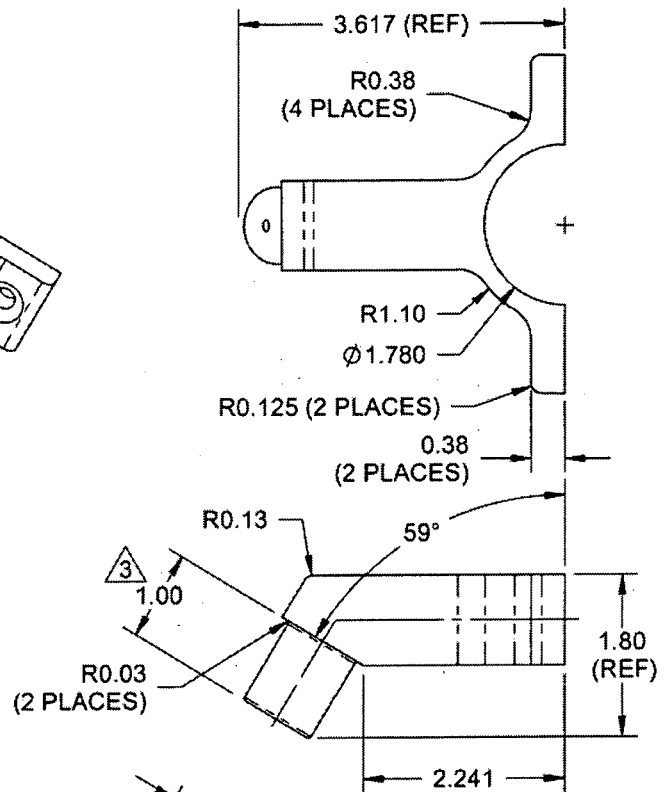
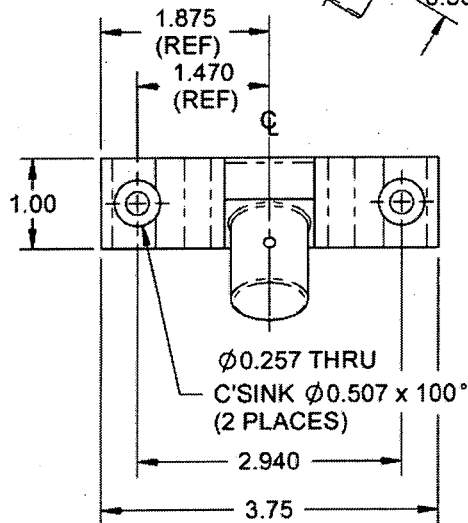
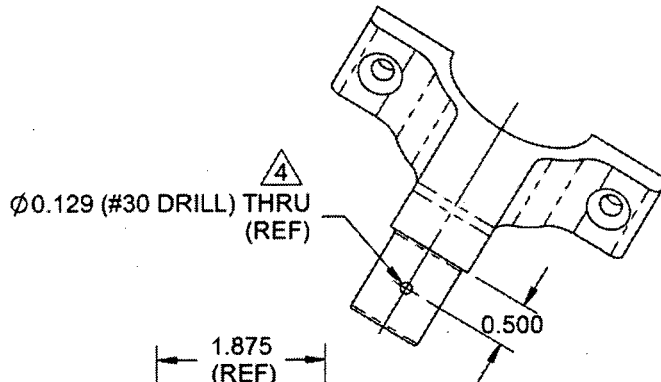
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO. D3440	REV. A SHEET 1 OF 7
DATE 05.06.02	TITLE BLADE FOLD KIT PARTS		SCALE 1:2
A	05.06.02	NEW ISSUE	

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05/09/18



D3440-1 TUBE GUIDE
SUPERSEDES PREMIER P/N B67-43001-25/-307

NOTES:

- 1) MATERIAL: 6061-T6 (OR 6061-T651/T6510/T6511/T62) BAR
PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116)
OR PER AMS/QT-A/200/8 (OR AMS 4160)
(REF. DART SPEC. M6061T6B)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT PAINT GREEN SANDTEX (4.3.5.8) PER DART QSI 005 4.3
- 3) MASK BEFORE PAINTING.
- 4) DRILL HOLE AT ASSEMBLY.
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES
- 7) BREAK ALL SHARP EDGES 0.005 TO 0.010

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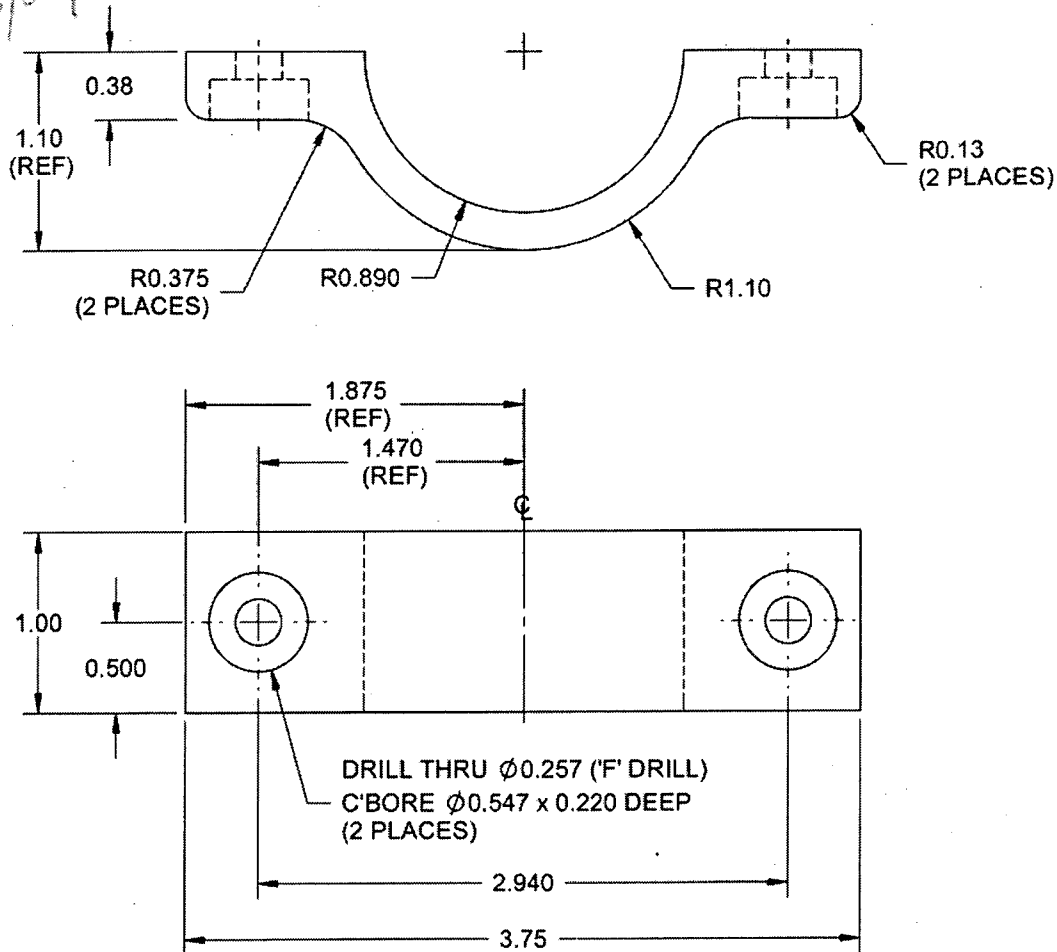
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DATE 05.06.02		TITLE BLADE FOLD KIT PARTS	SCALE 1:1

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**D3440-3 CLAMP****SUPERSEDES PREMIER P/N B67-43001-309****NOTES:**

- 1) MATERIAL: 6061-T6 (OR 6061-/651/T6510/T6511/T62) BAR
PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116)
OR PER AMS/QQ/A/200/8 (OR AMS 4160)
(REF. DART SPEC. M6061T6B)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT PAINT GREEN SANDTEX (4.3.5.8) PER DART QSI 005 4.3 WITHOUT NOTICE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

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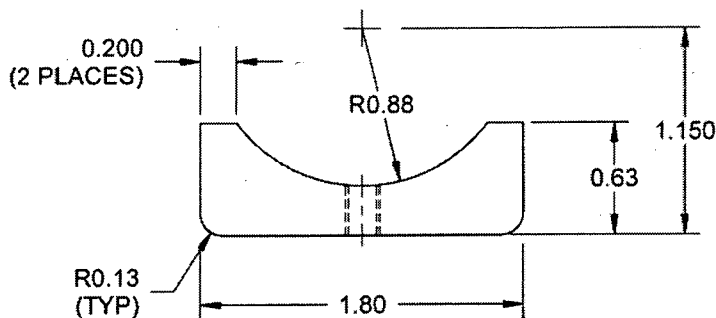
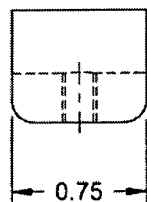
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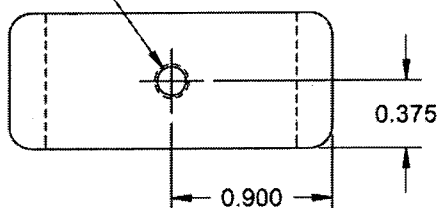
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DATE 05.06.02		TITLE BLADE FOLD KIT PARTS	SCALE 1:1

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DRILL $\varnothing 0.159$ THRU,
TAP #10-32 UNF THRU



D3440-5 CONTOURED DETENT CLIP BASE
SUPERSEDES PREMIER P/N B67-43001-217

NOTES:

- 1) MATERIAL: 6061-T6 (OR 6061-/651/T6510/T6511/T62) BAR
PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116)
OR PER AMS/QQ/A/200/8 (OR AMS 4160)
(REF. DART SPEC. M6061T6B)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

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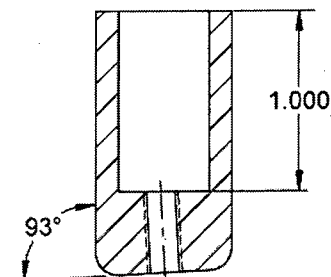
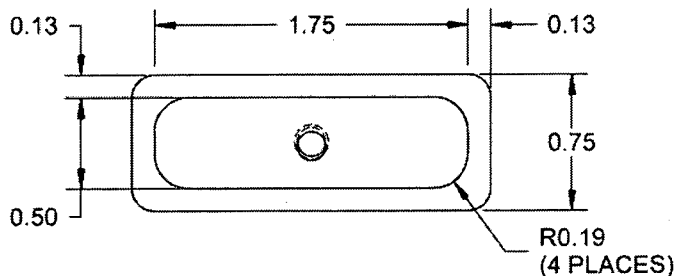
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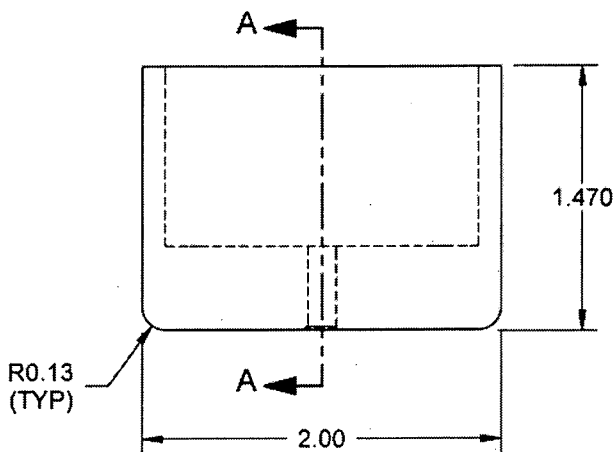
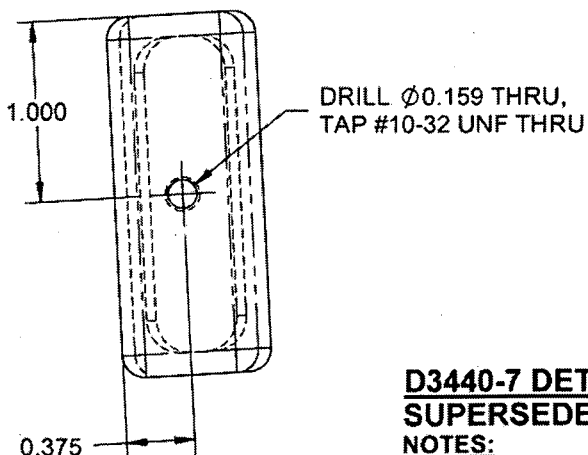


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SECTION A-A



D3440-7 DETENT CLIP BASE
SUPERSEDES PREMIER P/N B67-43001-221

NOTES:

- 1) MATERIAL: 6061-T6 (OR 6061-/651/T6510/T6511/T62) BAR
PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116)
OR PER AMS/QQ/A/200/8 (OR AMS 4160)
(REF. DART SPEC. M6061T6B)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

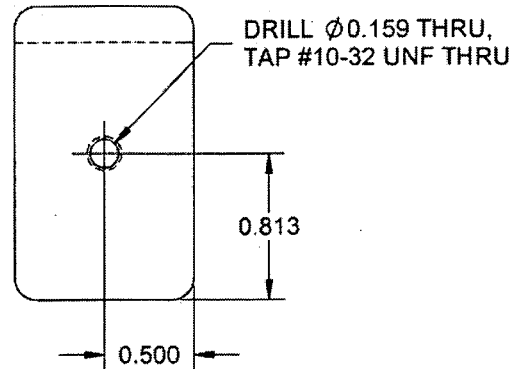
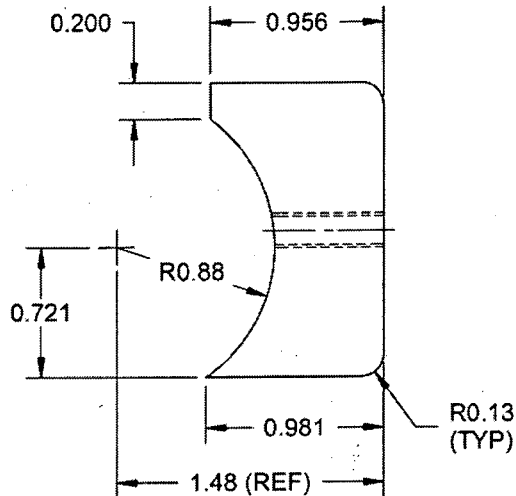
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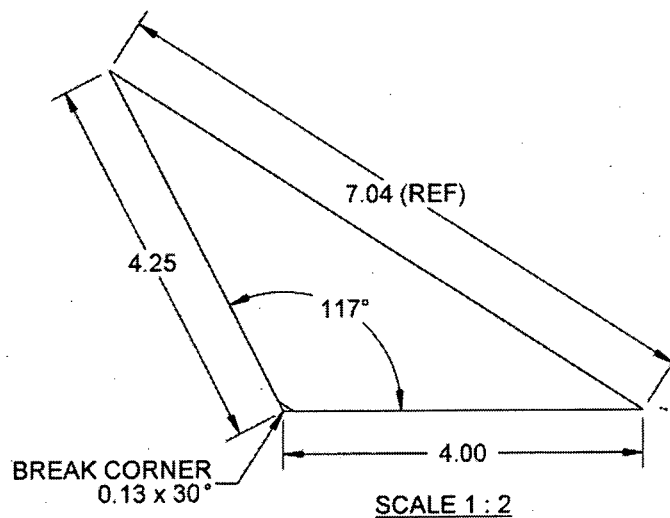
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DATE 05.06.02	TITLE BLADE FOLD KIT PARTS		SCALE 1:1



D3440-9 TUBE DETENT CLIP BASE
SUPERSEDES PREMIER P/N B67-43001-241

- 1) MATERIAL: 6061-T6 (OR 6061-T651/T6510/T6511/T62) BAR
PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116)
OR PER AMS/QQ/A/200/8 (OR AMS 4160)
(REF. DART SPEC. M6061T6B)

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SCALE 1:2

D3440-11 GUSSET

- 1) MATERIAL: 6061-T6 (OR 6061-T62) ALUMINUM SHEET
PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027
(REF. DART SPEC. M6061T6S.250)

NOTES:

- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
3) ALL DIMENSIONS ARE IN INCHES
4) BREAK ALL SHARP EDGES 0.005 TO 0.010

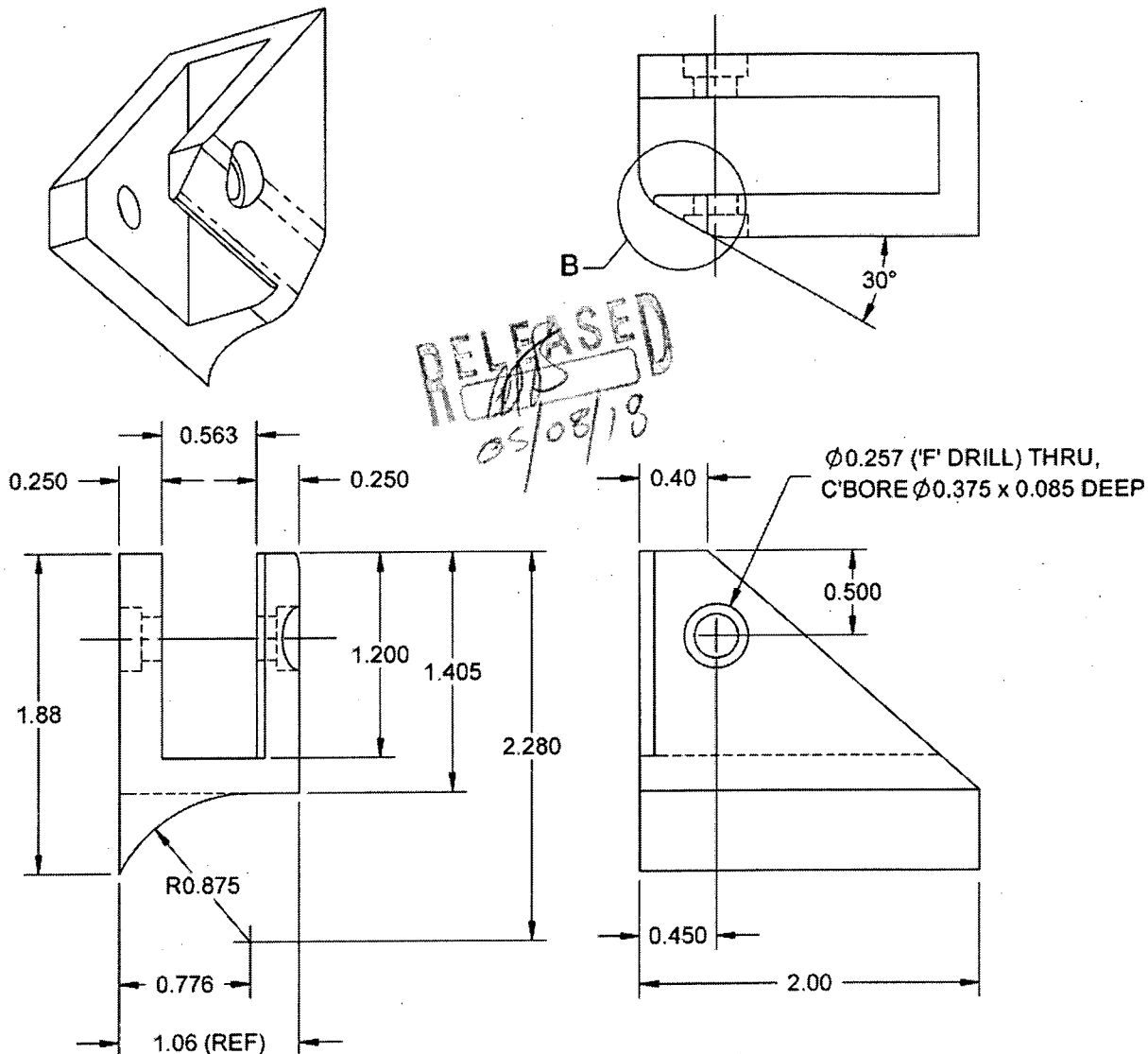
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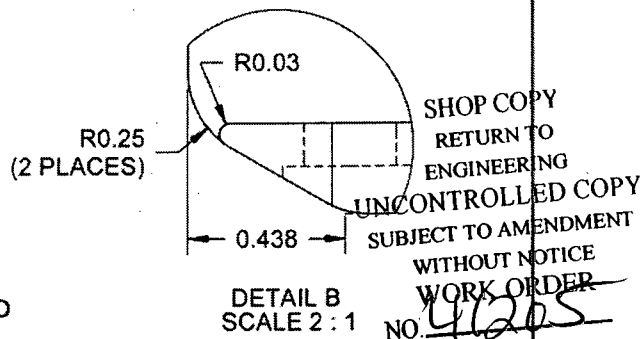
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DATE 05.06.02		TITLE BLADE FOLD KIT PARTS	SCALE 1:1



D3440-13 BRACKET
SUPERSEDES PREMIER P/N B67-43001-273

NOTES:

- 1) MATERIAL: 6061-T6 (OR 6061-/651/T6510/T6511/T62) BAR
PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116)
OR PER AMS/QQ/A/200/8 (OR AMS 4160)
(REF. DART SPEC. M6061T6B)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010



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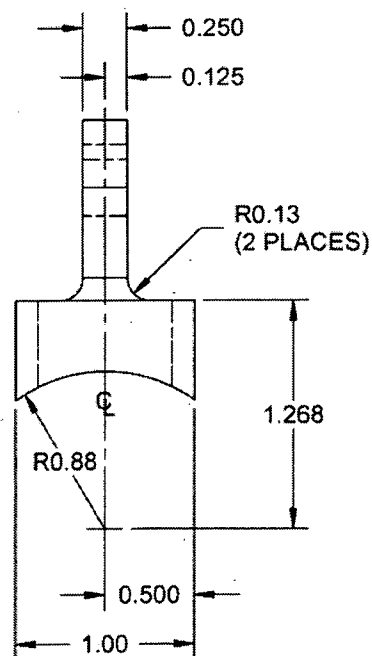
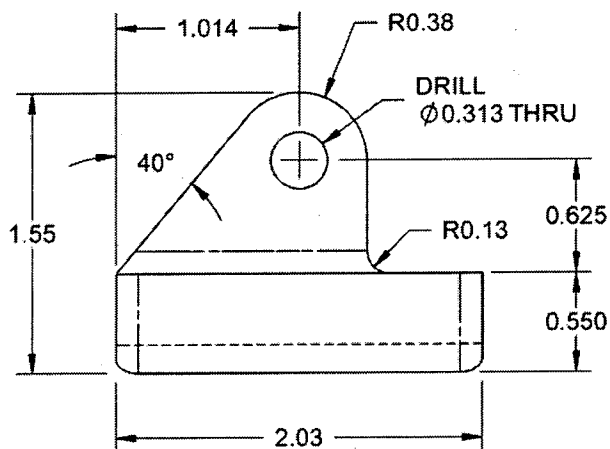
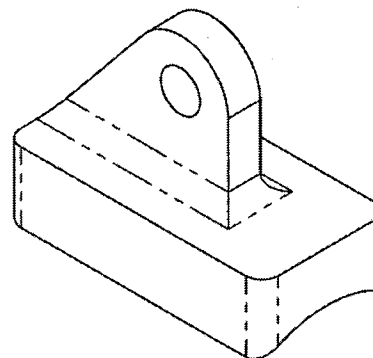
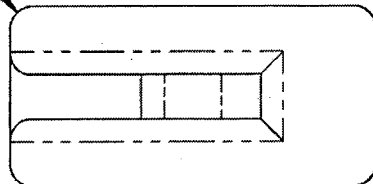
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DATE 05.06.02		TITLE BLADE FOLD KIT PARTS	SCALE 1:1

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05/08/18

R0.13
(4 PLACES)



D3440-15 CONTOURED MALE EYE
SUPERSEDES PREMIER P/N B67-43001-215

NOTES:

- 1) MATERIAL: 6061-T6 (OR 6061-T651/T6510/T6511/T62) BAR
PER AMS-QQ-A-225/8 (OR AMS 4160)
(REF. DART SPEC. M6061T6B)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

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